

Date: Friday, 23/03/2007 8:25:48 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ARM
Job Number : 31447	
Estimate Number : 12590	
P.O. Number : N/A	Part Number : D35604
This Issue : 23/03/2007 S.O. No. : N/A	Drawing Number : D3560 UNDER REVIEW <i>for replacement</i>
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL / MED FAB	Drawing Revision : A
Previous Run : 30867	Material : N/A
Written By : _____	Due Date : 26/03/2007 Qty: 3 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est Rev: A New Issue 06-11-10 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X06000	6061-T6 Bar .50" x 6.0"
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Comment: Qty.: 0.7350 f(s)/Unit Total: 2.2050 f(s) *2.9400*

6061-T6 Bar .50" x 6.0"

Batch: *ML10A19**ml 07 03 23*

(4)

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

1-Cut as per Dwg D3560

Dwg Rev: *A*Prog Rev: *A**ml 07 03 23*

(4)

2-Deburr if necessary

Note: .507" Dia & .196" Dia Holes are to opened on manual mill after Waterjet

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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*ml 07 03 23*

(4)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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**Comment:** CONVENTIONAL MILLING MACHINE

1-Open .196" Dia hole

2-C'Bore as per Dwg D3560.

3-Ream .507" as per Dwg D3560

Ensure to C'Bore on Corect side

MS 07103/23

(4)

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Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 07/03/26 (4)

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F. 07/03/26 (4)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA

J.F. 07.03.26 4

8.0

QC21

FINAL INSPECTION/W/O RELEASE



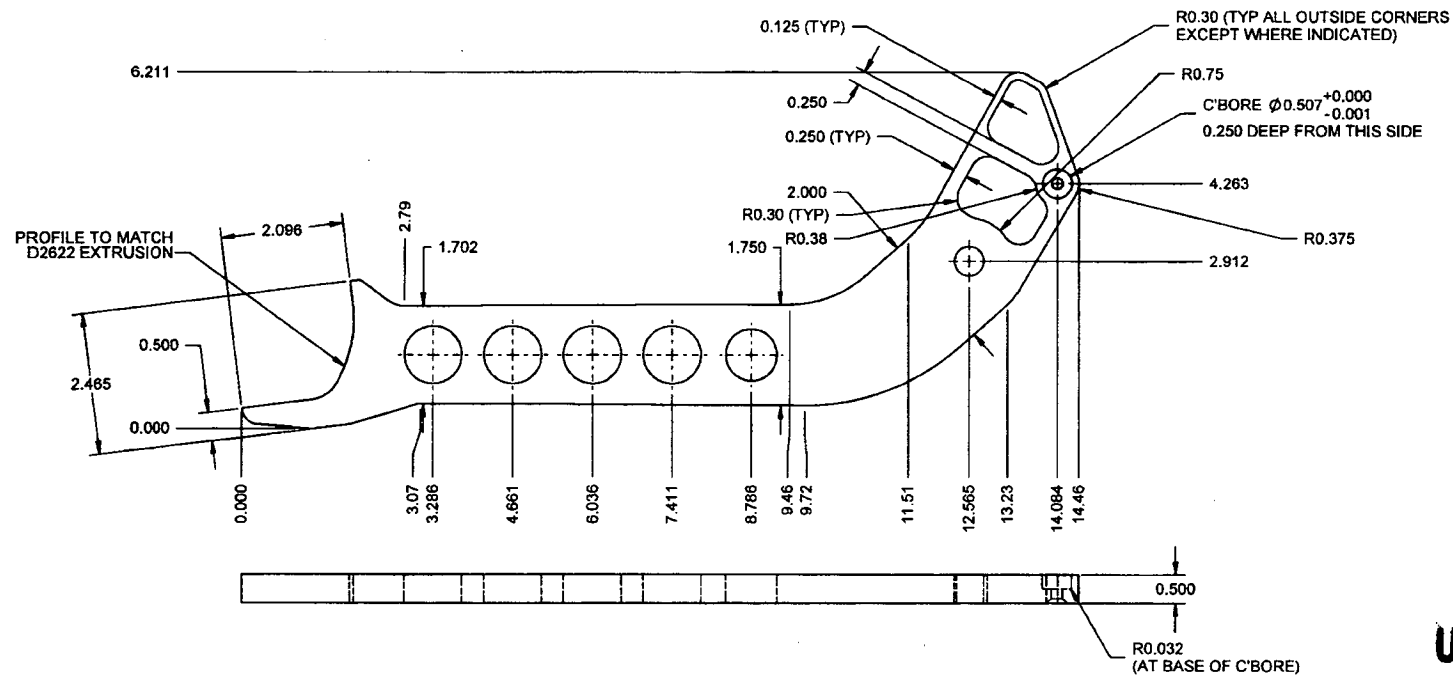
Comment: FINAL INSPECTION/W/O RELEASE

J.F. 07/03/26 (4)

Job Completion



U 07.03.26



UNDER REVIEW

07.11.07

RELEASED

06.11.07

D3560-3 ARM (SHOWN), D3560-4 ARM (OPPOSITE)

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM (QQ-A-200/8 OR QQ-A-250/11), 0.500 THICK (REF DART SPEC. M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS

DESIGN	97	DRAWN BY	97	DART AEROSPACE LTD
CHECKED	97	APPROVED	97	HAWKESBURY, ONTARIO, CANADA
DATE	06.09.25	DRAWING NO.	D3560	REV. A
		TITLE	ARM	SHEET 2 OF 2
		SCALE	1:2	

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DART AEROSPACE LTD		Work Order: 31447
Description: ARM		Part Number: D3560-4
Inspection Dwg: 3560 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☐ First Article ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	Ø 1.000	+0.012-0.001	1.003	✓		vern	
B	Ø 0.900	+0.010-0.001	0.902	✓		vern	
C	Ø 0.507	+0.008-0.001	0.507	✓		vern	
D	Ø 0.196	+0.005-0.001	0.201	✓		vern	
E	0.500	+/- 0.010	0.500	✓		vern	
F	0.250	+/- 0.010	0.252	✓		vern	
G	0.125	+/- 0.010	0.126	✓		vern	
H	0.250	+/- 0.010	0.250	✓		vern	
I	2.000	+/- 0.010	2.002	✓		vern	
J	1.750	+/- 0.010	1.748	✓		vern	
K	2.465	+/- 0.010	2.465	✓		vern	
L	1.702	"	1.704	✓		vern	
M	.507	+ .000 - .001	.507	✓			
N	.385 x 1000	+/- .010	.385	✓			
O							
P							
Q							
R							
S							
T							
U							
V							
W							
X							
Y							

Measured by: <i>M. M.</i>	Audited by:	Prototype Approval:	N/A
Date: 07 03 23	Date:	Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	